

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-17 Date Opened: 18 Feb 2015 Title: FabricationAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket Body Product Model: Long Quantity: 2**Work Order Contents**

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	JR
Completed Certification (Original)	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

Tasks Initialled	JR
Dual Inspections Initialled	JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
78411	3	Body Assembly	JR
76421	1	Regular Hoop	JR
76423	3	Mount Hoop	JR

Traveller

Work performed by: _____
ICC / Dual Inspection performed by: _____
Work Order closed by: _____

Print: J Rkve for M Rekve
Print: Jason Rekve
Print: Jason Rekve

Sign: Jason Rekve
Sign: Jason Rekve
Sign: Jason Rekve

Form 20.D.03

Component Completion

	As Instructed
Quantity Complete on This Work Order	2
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking Tags (White) Completed	JR
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

Local (Aero Design)	JR
Research and Development	N/A
Third Party	N/A

Approved Manufacturing Facility 73-04

SCA: AD01 Date: 20-Feb-15
SCA: AD01 Date: 20-Feb-15
SCA: AD01 Date: 01-Mar-15

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76421-01

Aircraft: Eurocopter

Model: AS350

Description: Short/Medium/Long Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A



Aero Design Ltd.

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V8A 0G3, 604-483-AERO (2376)

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Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76423

Aircraft: Eurocopter

Model: AS350

Description: Large Mount Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

76421-01

Aircraft:

Eurocopter

Model: AS350

Description:

Short/Medium/Long Hoop

Supplier:

Aero Design

Color:

N/A

WO#:

2014-29

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76421-01

Aircraft: Eurocopter

Model: AS350

Description: Short/Medium/Long Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A



WO# 2015-17

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

CARGO BASKET BODY FABRICATION - COMMON

AS350 LONG (2)

2015-17

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

→ 78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2015-17

Date Open: 18 FEB 2015

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

3. Inspection

- a. Rim for complete welds

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

AD-05 


- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection



- a. Frame assembly for complete welds.

7. Mesh assembly.



- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)
AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

OK

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

OK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2015-17Date Opened: 18 FEB 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

1 of 2

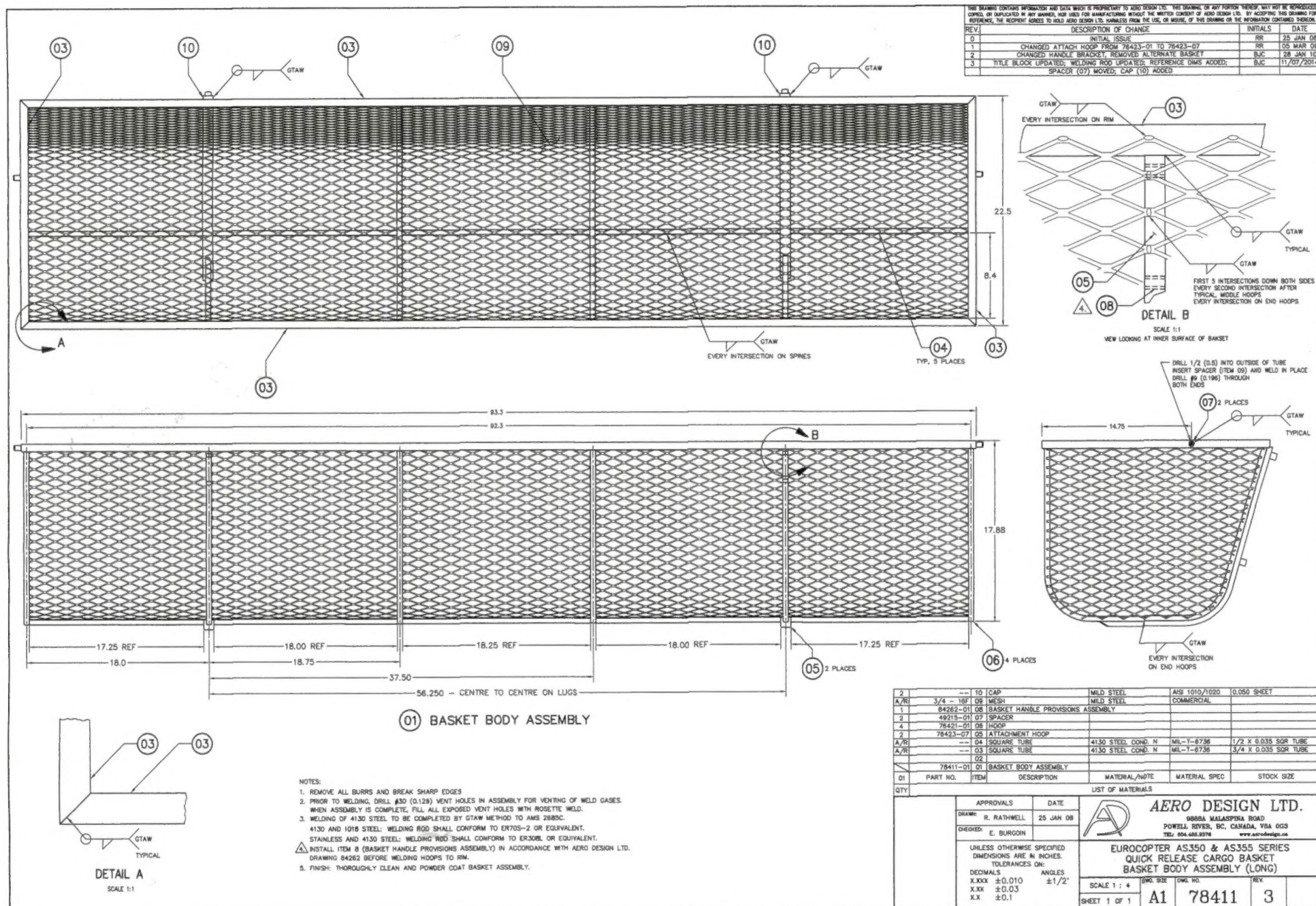
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			78411-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14076
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	1412
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2014-24
	. 2		76423-01	Attachment hoop (aft)		2014-24
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14053
Step 4.g.		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	N/A
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 92.25")	3/4-16F Expanded Mild Steel sheet	11032
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	11012
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	PO# 14028

Work Order: 2015-17Date Opened: 15 Feb 2015Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	WO# 2015-07
	. A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
Step 9.b.	. 2		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 9010
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 10				<i>Clean Up</i>	<i>None</i>	
Step 11				<i>Inspection - Final Assembly</i>	<i>None</i>	
Step 12				<i>Powder Coating</i>		

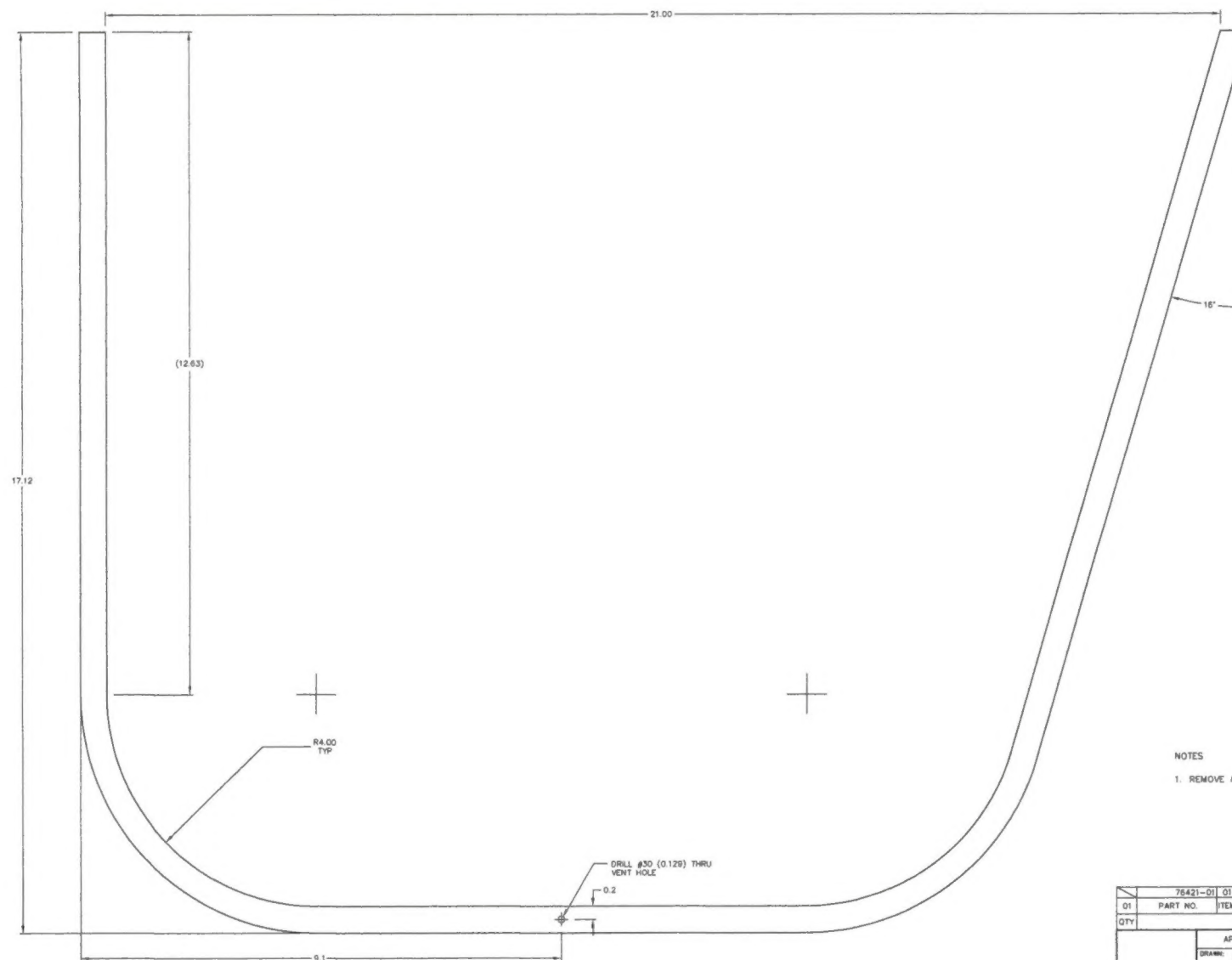
2015-17



2015-17

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; NOTE 2 REMOVED; ADD VENT HOLE	BJC	11/07/2014



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

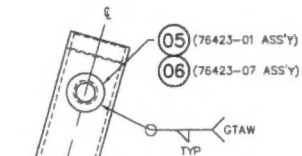
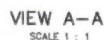
01 HOOP
SCALE 1 : 1

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	76421-01	01	HOOP	4130 STEEL COND. N	ML-T-6736	0.5 X 0.035 SQR TUBE
LIST OF MATERIALS						
APPROVALS			DATE	 AERO DESIGN LTD. 8080A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL. 604.683.8370 www.aerodesign.ca		
DRAWN: R. RATHWELL			24 JAN 08			
CHECKED: E. BURGON						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET HOOP		
DECIMALS		ANGLES		SCALE 1 : 1	DWG SIZE	DWG NO.
X.XXX ±0.010		±1/2°		SHEET 1 OF 1	A1	76421
X.XX ±0.03						1
X.X ±0.1						

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 00
1	ADDED 76423-07 ASSY AND 76433-08 PART	RR	09 MAR 00
2	CHANGED LENGTH OF SIUD (ITEM 05)	BJC	18 JUNE 01
3	TITLE BLOCK UPDATED; FORMAT UPDATED; LENGTH OF SIUDS (ITEM 05 & 06) CAP (ITEM 04) UPDATED; HANDLE PROVISIONS (ITEM 08) ADDED	BJC	14/05/2001



1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL #30 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS E70TS-2 OR EQUIVALENT.
- ⚠ M1. MILL SLOT INTO ITEM 1 TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
- ⚠ A2. ADJUST SLOT OF CAP (78423-04) TO FIT AS REQUIRED.
- ⚠ B. BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN DRAWING 84262. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.



VIEW C-C
SCALE 1 : 1
TYPICAL, 2 PLACES



ALL FEATURES SIMILAR TO 76423-01 EXCEPT STUDS. SEE SECTION C-C
SCALE 1 : 1

2	1	84272-01	09	BUSHING			
	1	84262-01	08	BASKET HANDLE PROVISIONS ASSEMBLY			
	2	76423-06	06	STUD	MILD STEEL	A/S 1010/1020	#0.63 ROD
	2	76423-05	05	STUD	MILD STEEL	A/S 1010/1020	#0.63 ROD
	1	76423-04	04	CAP	MILD STEEL SHEET	A/S 1010/1020	0.060 SHEET
A/R/A/R		03	TUBE 1/2IN	4130 STEEL COND. N	MIL-1-8736		0.5 X 0.535 SQR TUBE
A/R/A/R		02	TUBE LIN	4130 STEEL COND. N	MIL-1-8736		1 X 0.065 SQR TUBE
		76423-07	07	ATTACHMENT HOOP ASSEMBLY	(USED ON 78411)		
		76423-01	01	ATTACHMENT HOOP ASSEMBLY			
08	07	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	STOCK SIZE
QTY	QTY	QTY				LIST OF MATERIALS	
APPROVALS				DATE			
DRAWN:		R. RATHWELL		24 JAN 08			
CHECKED:		E. BURGOIN					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON				EUROQUOT AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET ATTACHMENT HOOP ASSEMBLY			
DECIMALS		ANGLES		DWG. SIZE		DWG. NO.	
X.XXX ±0.010		±1/2"		SCALE 1 : 1		REV.	
X.XX ±0.03							
X.X ±0.1							
SHEET 1 OF 1				A1 76423 3			